

shp Oct. 14

Work Order ID 74865

74865

~~PRELIMINARY ISSUE~~

Page 1

October-13-11 8:51:47 AM

Item ID: D4074-7

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Striker Plate

Stop

NS2

Start Date: 10/13/11 Start Qty: 2.00

2

Required Date: 10/13/11 Req'd Qty: 2.00

2

Reference:

Cust Item ID:

Customer:

~~PRELIMINARY ISSUE~~

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4074

100

100

Waterjet

FLOW CNC Waterjet

Handwritten: ~~CAP~~ *u.10.26*
ECN 11#657

Memo

0.00

1-Cut as per Dwg

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

Handwritten: 1B11-10-13

Handwritten: (9)

Handwritten: 1B11-10-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

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October-13-11 8:51:47 AM

74865

Page 2

Item ID: D4074-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Striker Plate

Start Date: 10/13/11 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/13/11 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

-inspector to
un release rec
Day only
8/11/13

(28)

SB 11/10/14

(2)

PTD
next page

-inspector to rec
un sign + un release
Day
8/11/14

W/O: 74865		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/10/14	130	Made 2 pieces for shipment today but next time I'll need a jig to make them Preliminary Preliminary part	SP	11/10/14	②	W	S 11/10/14

Part No: D4074-7 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74865

October-13-11 8:51:47 AM

74865

Page 3

Item ID: D4074-7

Revision ID:

Item Name: Striker Plate

Start Date: 10/13/11 Start Qty: 2.00

Required Date: 10/13/11 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

Shp EHA
ASAP

0.00

Packaging

10/11/14 (2)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

C of C issued
CR 10/11/17

11/10/2014 (ARC)

POSITIVE RECALL

EFFECTIVE 11/10/14 AUTH 11/10/14
RELEASED 11/10/14 DATE 11/10/14

POSITIVE RECALL

EFFECTIVE 11/10/13 AUTH 11/10/13
RELEASED 11/10/13 DATE 11/10/13

Released

11.10.26

Per ECN # 11-657

Picklist Print

October-13-11 8:51:47 AM

Page 1

Work Order ID: 74865
Parent Item: D4074-7
Parent Item Name: Striker Plate

Start Date: 10/13/11
Start Qty: 2.00
Required Date: 10/13/11
Required Qty: 2.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC
11-07-25 JLM VERIFIED BY:EC

IPP REV:B AS PER ECN 11-613

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	527.8050	0.0103	0.0216842	15		

B11-10-13

Location	Loc Qty	Loc Code
MAT020	527.805	
113062	0.005	
118217	1	
119032	206.8	
119188	320	

118217

9

Work Order: 74865

Description: STRIKER PLATE

Part Number: D4674-

Inspection Dwg: D4074-7, Rev: C

Page 1 of 1

X	First Article	X	Prototype
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Measured by: RB

Date: 11-10-13

Audited by:

Date: 11/10/13

Prototype Approval:

Date:

Rev

Date _____

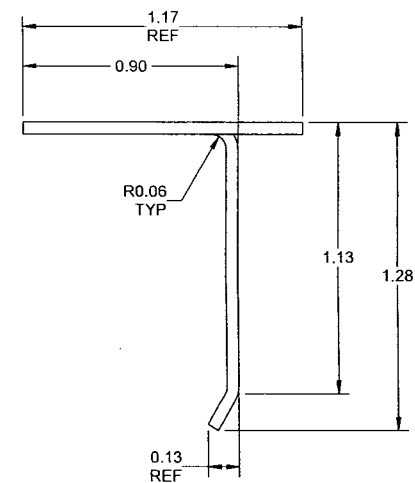
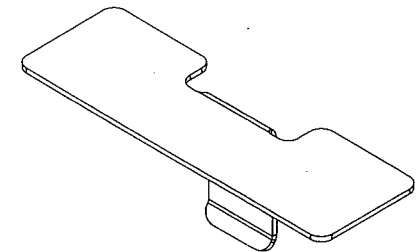
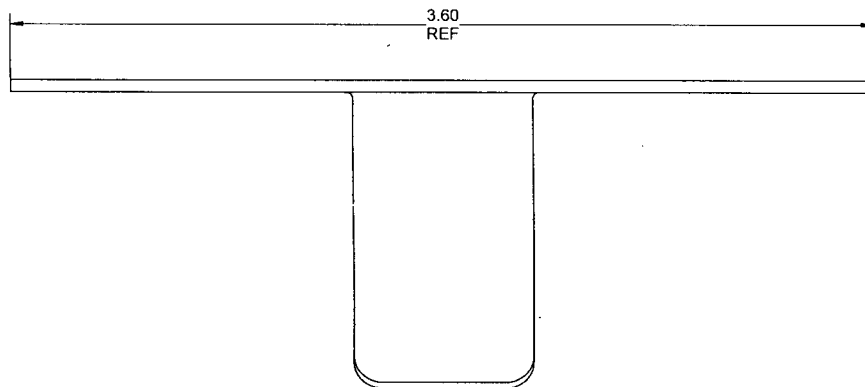
Change

New issue

Revised by

Approved

KJ/JLM



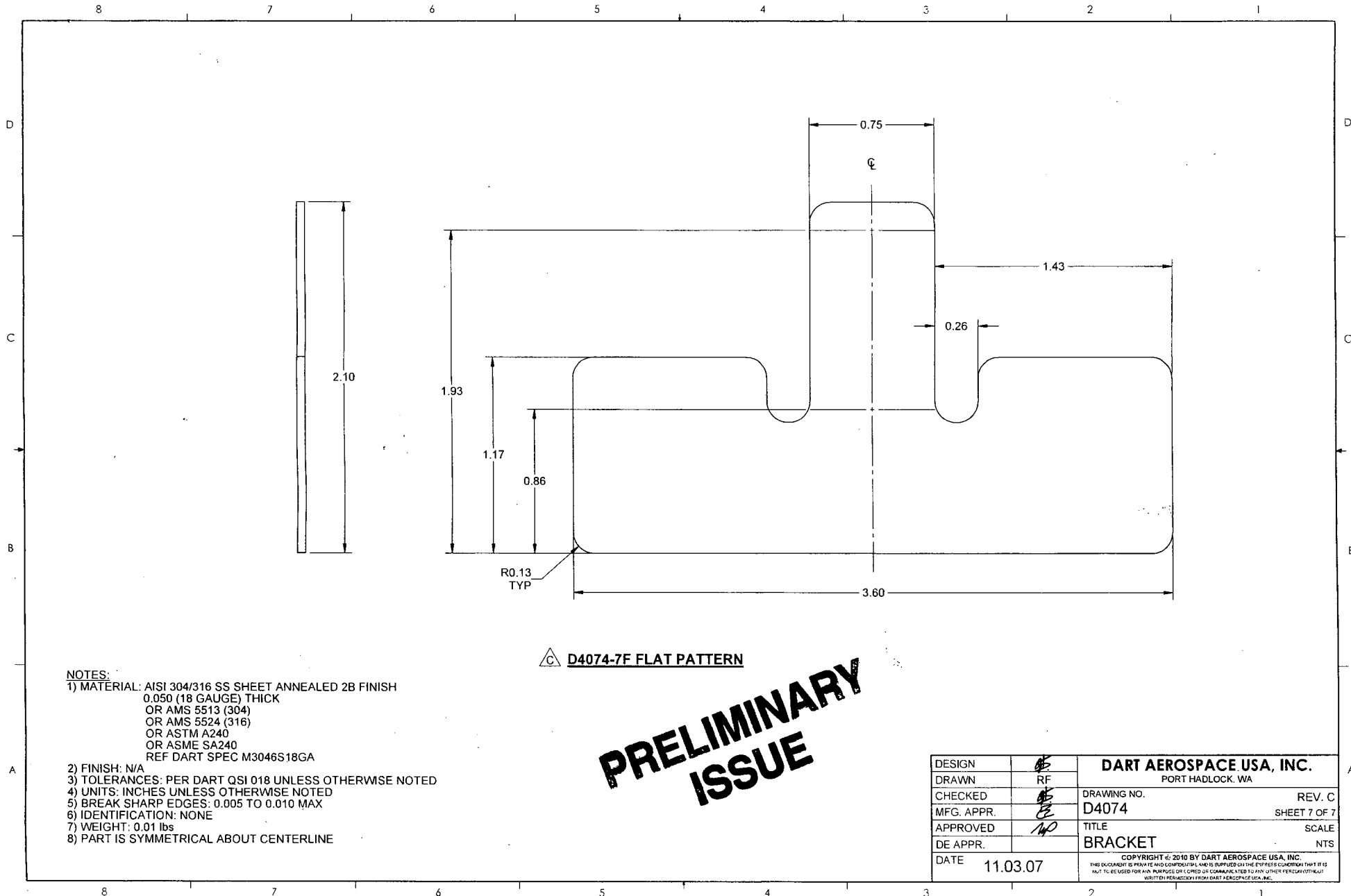
D4074-7 STRIKER PLATE
(MAKE FROM D4074-7F FLAT PATTERN)

**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: MAKE FROM D4074-7F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 6 OF 7
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NOTES:

1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH
0.050 (18 GAUGE) THICK
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC M3046S18GA

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4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.01 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

D4074-7F FLAT PATTERN

DESIGN	RF	DART AEROSPACE USA, INC.	
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Marc Bellavance

From: David Shepherd <dshepherd@dartaero.com>
Sent: October 12, 2011 7:29 PM
To: 'Linda Lacelle'; 'Eric Charbonneau'
Cc: Harvey Siemens; 'Sian Willems'; Mike Petsche; 'Bill Beckett'; Peggy McDonald; Carrie Pearson; 'Marc Bellavance'
Subject: FW: Emailing: Striker D4074-7, Airframe Striker Area
Attachments: Pages 6 + 7 from D4074-c.pdf

Follow Up Flag: Follow up
Flag Status: Completed

Eric,

We need to make a design change to D4074-7 based on feedback from the initial installs. Can you review the attached dwg for manufacturability ASAP.

Harvey,

PHI has blessed the dwg. If Eric is good with the dwg, can you send him the dxf file for the waterjet ASAP.

Linda,

Would like to ship 2 x D4074-7 Rev C to Keevin Comeaux at PHI by end of the day Friday.

Sian,

Going to need a no charge for this.

Peggy/Carrie,

Just FYI.

Thanks everyone for your help and patience as we work thru these issues.

David

-----Original Message-----

From: David Shepherd [<mailto:dshepherd@dartaero.com>]
Sent: October-12-11 2:46 PM
To: 'Delmas, Anthony'
Cc: 'Symes, Greg'; 'Comeaux, Keevin'; Mike Petsche (mpetsche@dartaero.com)
Subject: RE: Emailing: Striker D4074-7, Airframe Striker Area

Tony,

See attached modification to the D4074-7 striker plate. Please confirm

ASAP whether you think this will solve the edge distance problem you are experiencing and we will endeavor to ship you new parts to try on Friday.

Thanks,
David

-----Original Message-----

From: Comeaux, Keevin [<mailto:kecomeaux@phihelico.com>]
Sent: October-11-11 6:09 PM
To: dshepherd@dartaero.com
Cc: Delmas, Anthony; Symes, Greg
Subject: FW: Emailing: Striker D4074-7, Airframe Striker Area
Importance: High

David:

See below was sent to your business card email, but I noticed the wiring information was sent from this email.
See below. Need help ASAP!!

-----Original Message-----

From: Comeaux, Keevin
Sent: Tuesday, October 11, 2011 7:01 PM
To: David Shepherd (dshepherd@darths.com)
Cc: Symes, Greg; Delmas, Anthony
Subject: FW: Emailing: Striker D4074-7, Airframe Striker Area
Importance: High

David:

See below. I did get the wiring information. I have been off schedule and I sent this on 10/4/11 before breaking. I spoke to Greg Symes today and he said he had not had any response. I need a response ASAP!!
Please respond to all. I will be out of office the 12th & 13th, if you call my work number my lead Tony Delmas will help you.

Best Regards,

Keevin Comeaux
Heavy Ship Hangar Manager
PHI, Inc.
2001 S.E. Evangeline Thruway
Lafayette, La. 70509
Phone: 337-272-4301
Fax: 337-235-3855

-----Original Message-----

From: Comeaux, Keevin
Sent: Tuesday, October 04, 2011 4:42 PM
To: David Shepherd (dshepherd@darths.com)
Cc: Symes, Greg
Subject: Emailing: Striker D4074-7, Airframe Striker Area
Importance: High

David:

We need the wiring information for the baggage door existing light switch as per our telephone conversation.

Also the striker P/N D4074-7 page

14 we want to know if the striker goes on top of frame which is the only place it can because as shown in airframe striker photo the hole is too small to insert from bottom. Installing the striker on top side of airframe as shown on page 14 of your installation instructions as shown in Striker photo we do not have edge distance using the existing holes from the previous hinge install. SO if you can give us the authorization we can drill two new holes and locate.

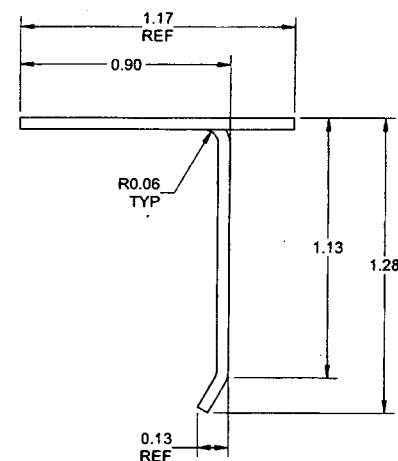
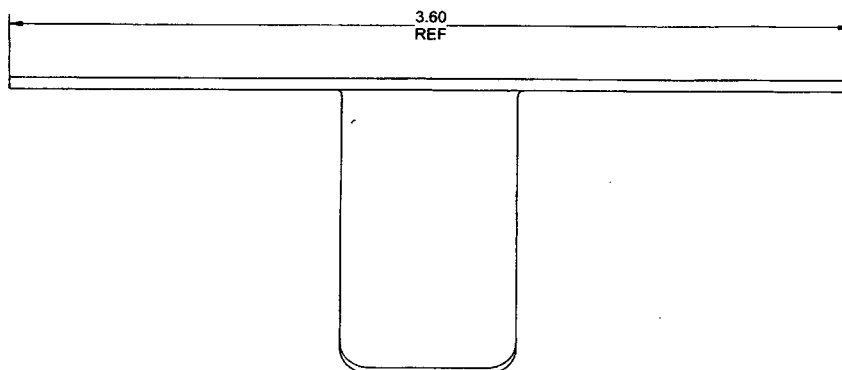
Best Regards,

Keevin Comeaux
Heavy Ship Hangar Manager
PHI, Inc.
2001 S.E. Evangeline Thruway
Lafayette, La. 70509
Phone: 337-272-4301
Fax: 337-235-3855

Your message is ready to be sent with the following file or link attachments:

Striker D4074-7
Airframe Striker Area

Note: To protect against computer viruses, e-mail programs may prevent sending or receiving certain types of file attachments. Check your e-mail security settings to determine how attachments are handled.



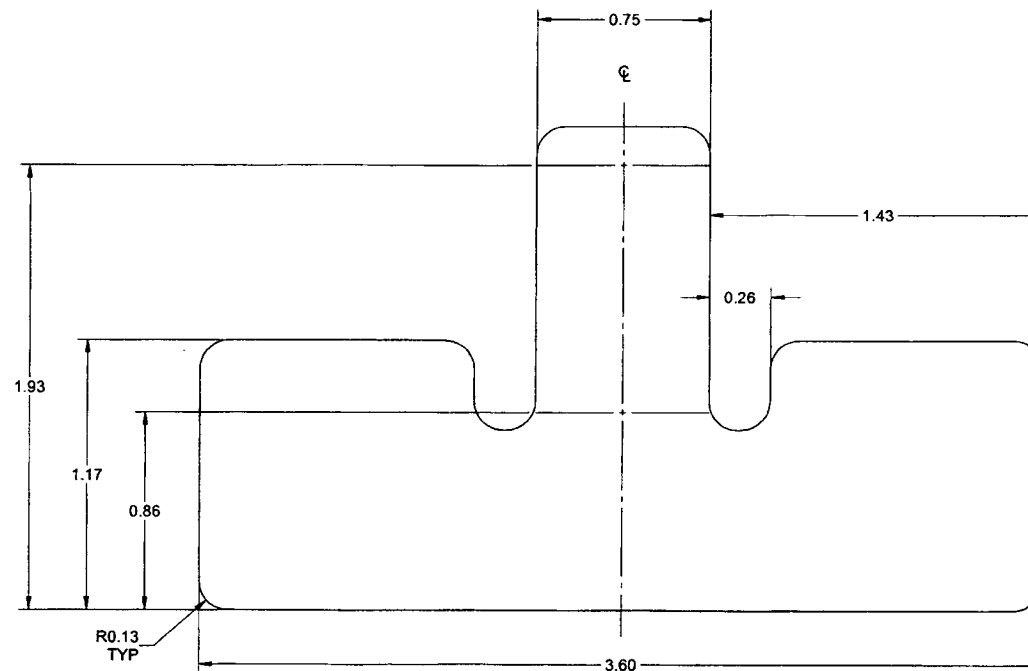
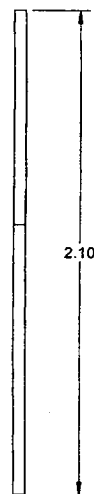
D4074-7 STRIKER PLATE
(MAKE FROM D4074-7F FLAT PATTERN)

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DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 6 OF 7
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74865
RELEASED
2011-10-26
JMB



D4074-7F FLAT PATTERN

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8) PART IS SYMMETRICAL ABOUT CENTERLINE

24865

2011-10-26

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MFG. APPR.	RF	D4074	SHEET 7 OF 7
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